



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4038-3
Job Sheet 169456



Part No: D4038-3

Job Qty: 6 ea

Part Name: Angle, Aft, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/12/17

Job Tracking No:

Due Date: 12/18/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV E SHEET 5 lpp Rev:A New Issue 09-12-15 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/18/17	0.00	0.00	Start Up Machining-2		
100	Bandsaw	6 pcs		12/18/17	0.00	0.00	Bandsaw1		
110	CNC Vertical Machining	6 pcs		12/18/17	0.00	0.00	HAAS1-4		
120	QC	6 pcs		12/18/17	0.00	0.00	QC2 Machining-2		
130	QC	6 pcs		12/18/17	0.00	0.00	QC8 Machining-2		
140	HandFinish	6 pcs		12/18/17	0.00	0.00	HandFinish1		
150	QC	6 pcs		12/18/17	0.00	0.00	QC3		
160	Packaging	6 pcs		12/18/17	0.00	0.00	Packaging3-2		
170	QC21-SA	6 Ea		12/18/17	0.00	0.00	QC21		

Part Op 100 - Cut Blank 7.625" long

Descriptions: 110 - Mill as per Dwg & Folio FA880 Dwg Rev: AAE Folio Rev: AA Deburr

JAN 12 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6A4.000W.250	4	7	0	0

Part Specifications

Specifications could not be found.

FM 118106 → S027849

Plex 12/12/17 10:18 AM dart.poulin.mario

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS					
Part No. _____		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. _____		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐		
		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
	Large Fab ☐	Composite ☐	Supplier ☐				

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval _____
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Description Work Order Deviation	Disposition
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Start up Operation Mfg Date: 01/02/18 Job No: 169456 Change No: Operation: Revision: PART NO: D4038-3	Completed By _____
	Lead hand / Supervisor Approval Verification _____
	QC / QA Coordinator Approval _____

Root Cause Environment ☐ No Re-verificati Design ☐ Operator Doc/Data ☐ Offset/Setup Equip/Tooling ☐ Supplier Handling/Pre ☐ Training Material ☐ Use for Testing Internal Transport ☐ Poor Informat Tribal Knowledge ☐ Rushing LOA ☐ Product Imprc Substation ☐ Process Improvement Past Expiry Date ☐ Manufacturing Process Misidentified ☐ Past Due		Marks/Chatter _____ OTHER : _____	DART AEROSPACE 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	Barcode: S027893 Angle, Att, LH	rge ☐ Positioned Wrong Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Drawing Finish Misread Turning Sequence
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DART AEROSPACE LTD		Work Order:	169456
Description: Angle, Aft, LH		Part Number:	D4038-3
Inspection Dwg: D4038	Rev: E	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.00	+/-0.030	3.998	/		Vern cal-2	
1.25	+/-0.030	1.249	/		"	
4.00	+/-0.030	3.998	/		"	
1.25	+/-0.030	1.249	/		"	
0.250	+/-0.010	0.248	/		"	
R0.250	+/-0.010	R.250	/		Gage	
2.904	+/-0.010	2.904	/		31006	
0.581	+/-0.010	0.581	/		Vern cal-2	
0.669	+/-0.010	0.669	/		31006	
0.735	+/-0.010	0.735	/		"	
0.500	+/-0.010	0.501	/		"	
2.00	+/-0.030	2.001	/		Vern cal-2	
0.500	+/-0.010	0.501	/		31006	
Ø0.316	+0.006/-0.001	0.318	/		Pin Gage	
Ø0.189	+0.005/-0.001	0.193	/		Pin Gage	
R0.13	+/-0.030	R.130	/		Gage	
0.70	+/-0.030	0.698	/		Vern cal-2	
1.000	+/-0.010	0.998	/		31006	
1.500	+/-0.010	1.498	/		"	
0.50	+/-0.030	0.502	/		Vern cal-2	
7.50	+/-0.030	7.501	/		"	
1.750	+/-0.010	1.750	/		"	
1.270	+/-0.010	1.268	/		"	
R0.13	+/-0.030	R.0.130	/		Gage	
0.589	+/-0.010	0.589	/		Vern cal-2	
2.125	+/-0.010	2.126	/		"	
1.00	+/-0.030	1.002	/		"	
1.19	+/-0.030	1.188	/		"	

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Preliminary Approval:
Date: 17/12/28	Date: 18-01-05	Date:

Rev	Date	Change	Revised by	Approved
A	10.06.08	New Issue	KJ	
B	11.04.05	Dimensions updated per Dwg Rev D	KJ	
C	11.06.21	Dimensions updated per Dwg Rev E	KJ	